

5/28

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23709
<b>Description:</b> Window Assembly	<b>Part Number:</b>	D3136-041
04.06.09		
<b>Dwg:</b> D3136 Rev. <del>B</del> C	<b>Qty:</b>	20
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PL	05.06.29	20
2	PG	Issue P/O: 2008296 Order D3136-1 per Dwg D3136 Supplier: -Canus Material: Polycast II Clear Acrylic sheet per MIL-P-5425 0.125" thick Apply 3M Protective Masking Film both sides <b>Material release note required</b>	U	05.06.29	20
3	RG	Receive and Inspect for transit damage <b>Ensure that material release note is attached</b>	CL	05/10/21	20
4	QC6	Inspect dimensions as per Dwg D3136	2	05.10.28	20
5	GA	Trim back masking film as per Dwg D3136 and apply D3108-9 decals to inside surface of windows. D3108-9 Batch: B22608	DL	05/11/24	20
6	GA	Engrave Part number and Batch number as per Dwg D3136 See CP about location of batch No. 05.06.29	DL	05/11/24	20
7	QC5	Inspect work to Step 6	2	05.11.30	19
8	ST	Identify and Stock as D3136-041 LOC. 85	CL	05/12/01	19
9	AC	Cost / part	Suc	05-12-08	19
10	DC	Close W/O Inspect Level 21	G	05/12/02	19

(PTO)

Rev	Date	Change	Revised By	Approved
A	03.11.28	New issue	KJ/DS	
B	04.02.04	Reformat	KJ/DS	#

RELEASED  
04.02.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-11-30	5	Labels: engraving was done on the top of the window but mistake on A Qty of Five.		Engraving on top is acceptable this time, Remove and replace decals 03108-9 (822608) and Apply AS per Dwg 3136	 05/11/30	 05-11-30		 05-11-30
05-11-30	7	Knicks on edge of window 0.050" x 0.040" deep. Too deep will cause a big dip on the edge if removed. Noticed at step 4, but removed. no good to remove.		Scrap: destroy 1x 3136-1 window	 05-11-30	 05-11-30		 05-11-30

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   

NOTE: Date &amp; initial all entries

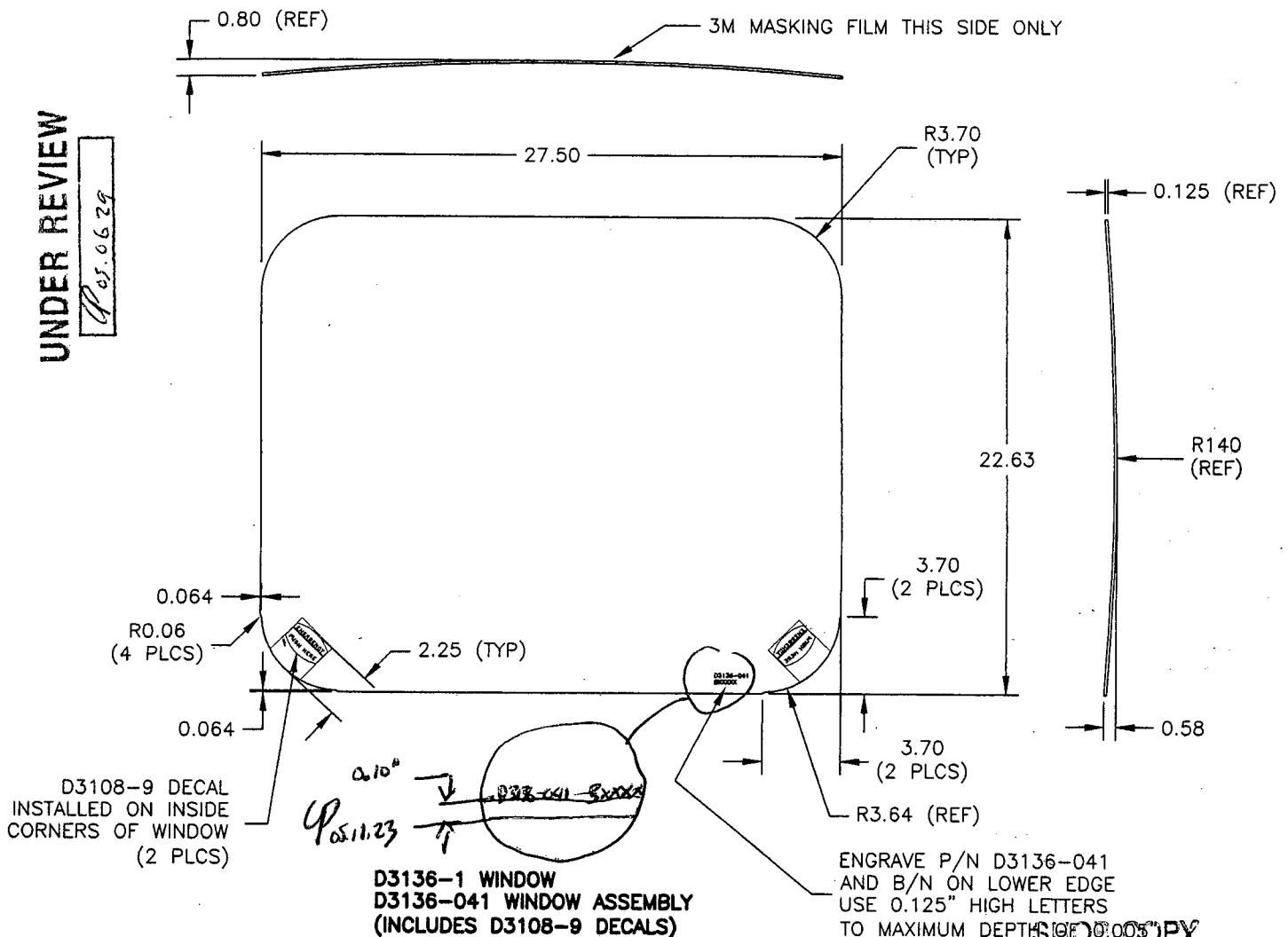
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD	REV. C
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3136	SHEET 1 OF 2
DATE	04.05.05	TITLE	WINDOW ASSEMBLY	SCALE	1:8
A	02.04.18	NEW ISSUE			
B	04.01.21	ADDED D3136-3 AND D3136-043			
C	04.05.05	ADDED FORMING & ENGRAVING SPEC			

RELEASED  
04.05.12

UNDER REVIEW  
05.06.29



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F  
b) DRAPE OVER D3136-T1 MOLD & CLAMP  
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS  
d) TRIM PER TEMPLATE D3136-1T2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER  
NO. 23709

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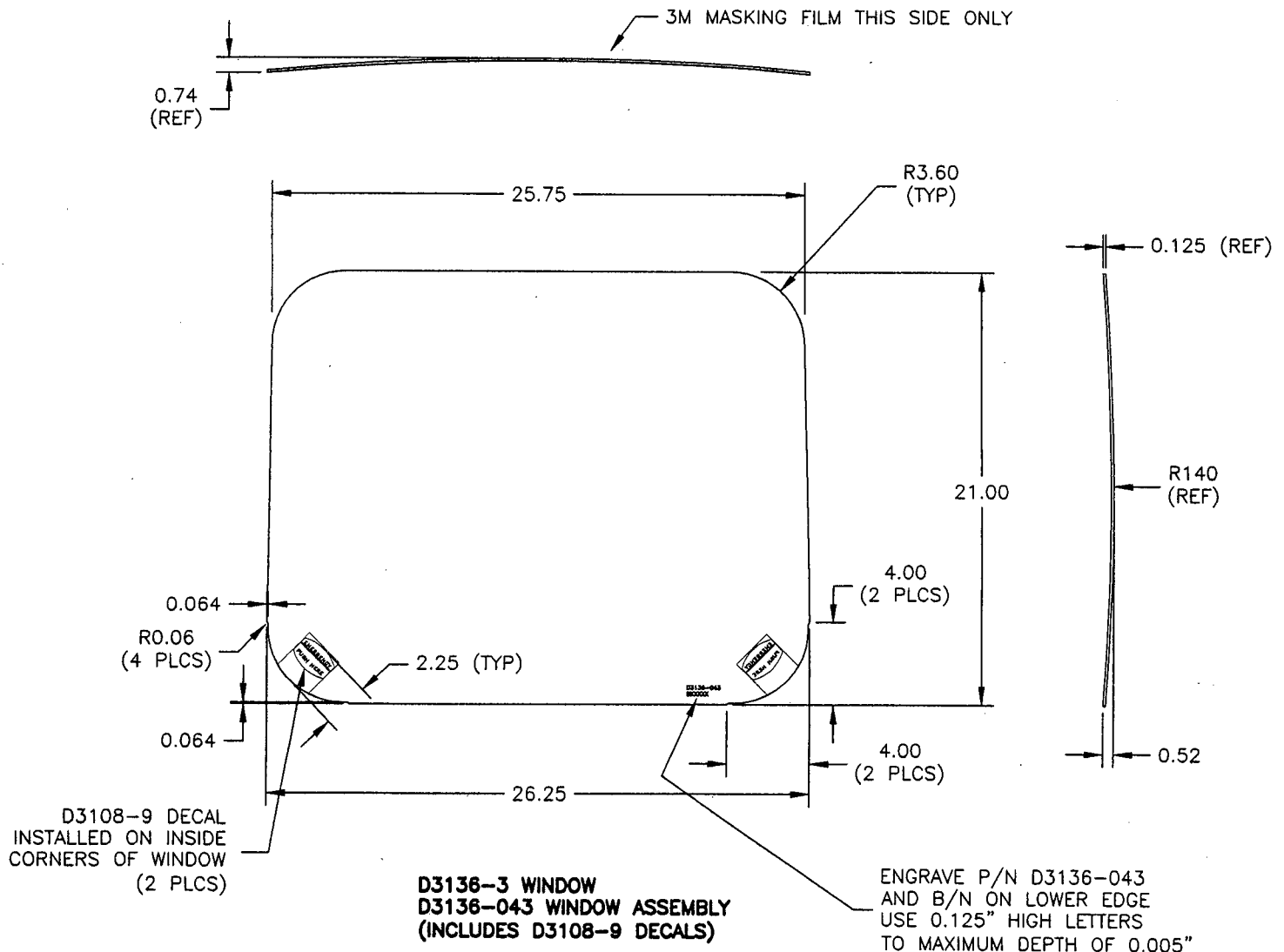
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3136	REV. C SHEET 2 OF 2
DATE 04.05.05		TITLE WINDOW ASSEMBLY	SCALE 1:8

RELEASED  
04.05.12

UNDER REVIEW  
04.06.29



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 0.125 THICK
- 2) FORMING PROCESS:
  - a) HEAT LARGER PIECE TO 250° F
  - b) DRAPE OVER D3136-T1 MOLD & CLAMP
  - c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS
  - d) TRIM PER TEMPLATE D3136-3T1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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NO 23709

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 28, 2005  
10:11 am

Work Order No : 0023709  
Project Name : D3136-041  
Project For : WK528  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3136-041  
Description : Window Assembly  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 06-28-05  
Est Finish Date : 07-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



**CANUS** Plastics Inc.

300 LISGAR ST  
OTTAWA, ONTARIO  
K2P 0E2  
PH: 613-232-2657  
FAX: 613-232-6214

Certificate of Conformance

Date: 10/18/05

To: DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY, ON  
K6A 1K7

P.O.#: 2008296

Order# 120506

The undersigned hereby certifies that the materials supplied and the items shipped under the above purchase order, are in conformance with, all applicable specifications and/or purchase order requirements. All reports of the materials supplied are on file and can be made available upon request.

<u>Quantity</u>	<u>Description</u>	<u>Specification</u>
20	D3136 REV C WINDOW ASSY	.125" CLEAR CAST ACRYLIC

SIGNED: \_\_\_\_\_